

Date: Wednesday, 6/6/2007 1:58:04 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE BLOCK		
Job Number	: 32797		Part Number	: D1049		
Estimate Number	: 10324		Drawing Number	: D1049 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 6/6/2007	S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: MACHINED PARTS			
Previous Run	: 29770		Due Date	: 7/1/2007	Qty:	50
Written By	:		Um:	Each		
Checked & Approved By	:					
Comment	: Est RevC 02.04.10 Re-format NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250
Comment: Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s) Material: 6061-T6 bar .750 wide x .250 thick. Batch M1938C		
2.0	SHEAR	SHEAR
Comment: SHEAR Cut Blanks: 2.000" long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		
1-Machine as per folio FA217 & Dwg D1049		
2-Deburr		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 32797

Part Number: D1049

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11 07-12-17

X50

7.0 POWDER COATING

POWDER COATING



M100700

50X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m 1 07/12/17

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

62 07/12/17 50

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST2

W 08/01/18

X50

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2007/12/18

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32797
Description: Saddle	Part Number:	D1049
Inspection Dwg: D1049	Rev: --	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

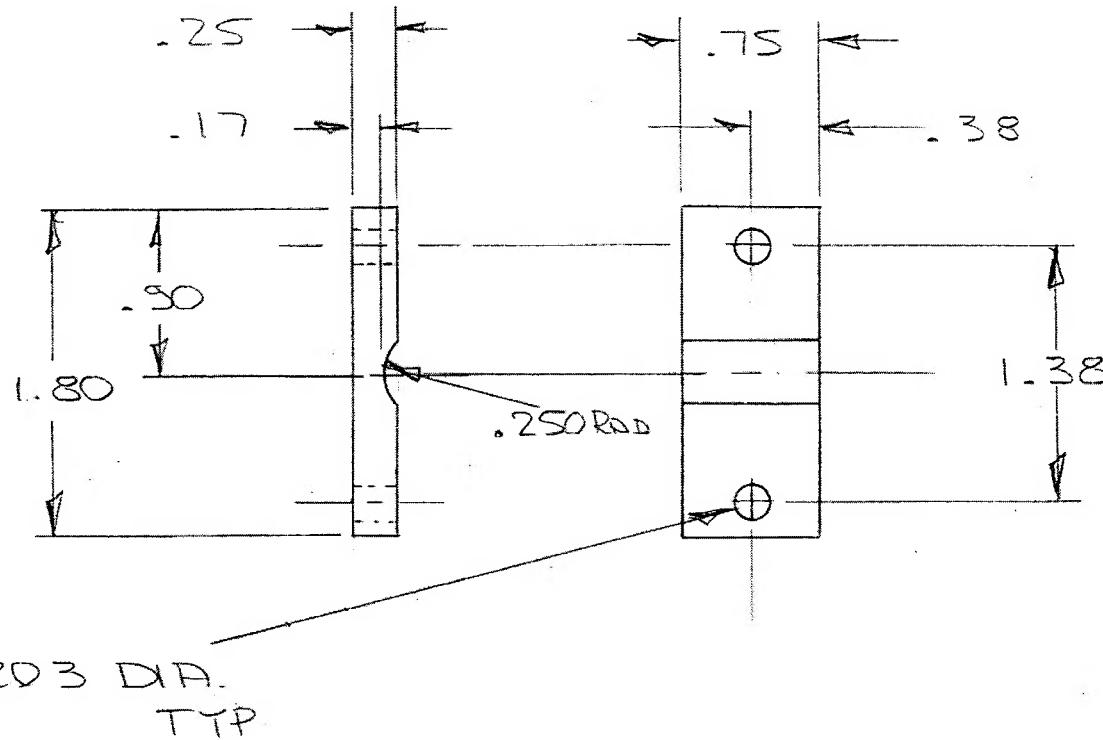
Measured by:	DJP
Date:	07/12/14

Audited by:	
Date:	02.02.2021

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TT

RELEASED
97/09/02 BW



MATERIAL : 5052-H32

FINISH : POWDER COAT

SHOP COPY
RETURN TO
ENGINEERING COPY
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 32797



REVISION	REVISION	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		BASIC CODE	DIA. DASH NO. M=HEAD REAR SIDE P=HEAD F/R SIDE	CONTRACT NO.			
APPROVED	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		DRAWN DRAFT DESIGN STRESS CHECKED CLIENT	LENGTH DASH NO. W=SPOTWELD	DRAWN DESIGN STRESS CHECKED CLIENT	DATE 10/17 1992	DART	DART AERO ACCESSORIES INC. VANCOUVER CANADA
DESCRIPTION OF CHANGE	GENERAL	UNITS	BASIC CODES		ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .014 3. TOLERANCES - .001-.015 MAX 4. THREADS PER IN. - 1742 5. HOLES PER IN. 10367 6. HOLEY LINE	1. TOLERANCES - .001-.010 2. ANGLES .001-.010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005 ALL M/C CENTRE LINES .005	BL-M5204700 BL-M5204260					
	REPORT ALL DISCREPANCIES - DO NOT SCALE		CODE	DWG. NO.				REV.
				D1049				
			SCALE	1:1	SHT	1 OF 1		